

79473

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Run Start *NR1*

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr
D2344	Rev F

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

2074.063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79473

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Item ID: D2344

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Deck Plate, 350

Start Date: 26/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges 2-Countersink holes per Dwg D2344

EP 12/02/07 (7)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Sizelox

(7)

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

7 BK 122-7.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 79473

79473

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Item ID: D2344 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Litter Deck Plate, 350
Start Date: 26/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 09/02/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
-----	---	------	--	--	--	--	--	--	--

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

7x d m 12/02/07

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

7x d m 12/02/07
COUNTED & IDENTIFIED

180

Identify as per dwg & Stock Location: 224

0.00

180

Packaging

Packaging

Memo

0.00

12/2/8 s4 70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

79473

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 26/01/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 09/02/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

190

QC

Memo

0.00

Quality Control

KL 02-8
(7)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79473

79473

Parent Item: D2344

D2344

Parent Item Name: Litter Deck Plate, 350

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	217.0000	0.745	4.705263	5.5		
									**		B12-2-6		
M2024T3S 063													
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT022

217

117392

25

119916

192

117392

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	79473
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.225	2		V 1B02	
5.598	+/-0.010	5.604	2		V	
4.869	+/-0.010	4.872	2		V	
3.889	+/-0.010	3.890	2		V	
3.096	+/-0.010	3.094	2		V	
2.891	+/-0.010	2.893	2		V	
16.973	+/-0.010	16.973	2		T 1B01	
0.450	+/-0.010	.449	2		V	
4.423	+/-0.010	4.422	2		V	
4.723	+/-0.010	4.723	2		V	
1.202	+/-0.010	1.204	2		V	
5.869	+/-0.010	5.870	2		V	
4.654	+/-0.010	4.659	2		V	
Ø0.656	+0.005/-0.000	.656	2		V	
1.888	+/-0.010	1.897	2		V	
2.285	+/-0.010	2.283	2		V	
2.683	+/-0.010	2.683	2		V	
Ø0.171	+0.005/-0.000	.171	2		V	
3.491	+/-0.010	3.492	2		V	
Ø0.191	+0.005/-0.000	.191	2		V	
3.123	+/-0.010	3.121	2		V	
1.975	+/-0.010	1.977	2		V	
Ø0.128	+0.005/-0.001	.129	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-2-6	Date: 12/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
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